

Work Order ID 56750

March 8, 2010 9:21:34 AM



Page 1

Item ID: D2574

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, Aft In 205

Start Date: 09/03/2010 Start Qty: 8.00

Cust Item ID:

Required Date: 23/03/2010 Req'd Qty: 8.00

Customer:

Reference:

10-03-16

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2574

Rev E

0.00

100



HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

0.00

Memo

Program Batch No. *56750* Double check by: *[Signature]* ☐ 1-Machine Step No 1
per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2
per Folio FA051 and inspect per attached Dimension Sheets ☐ 3-Machine Step No 3
per Folio FA051 and insp

DT 10/03/10

8 *φ*

110



Mill Conv

Conventional Milling Machine

CONVENTIONAL MILLING MACHINE

0.00

Memo

Machine keyway as per dwg D2573 & D2574

mm
10/03/10

8 *φ*

120



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

mm
10/03/10

8 *φ*

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	LB 10/03/22			8	0		
140 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00	H 10/03/22			(XF)	9		
150 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum 1113170 Memo START TIME: 9:30AM FINISH TIME: 10:00AM OVEN TEMPERATURE: 320°F	0.00 0.00	=2 H 10/03/23			(XF)	9		

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Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00

BF 10-3-23

8 4



QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: 437

0.00



Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/03/23 (F)

10/03/24

BF 10-3-23

Picklist Print

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March 8, 2010 9:21:34 AM

Work Order ID: 56750



Parent Item: D2574



Parent Item Name: Saddle, Aft In 205

Start Date: 09/03/2010

Required Date: 23/03/2010

Comments: IPP Rev: I As Per RevE 06-01-27 JLM

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6101-005		Manufactured	No			110	Each	106.0000	8.0000			



Saddle Billet

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

46411

106

106

8 DJP 10/03/16

DART AEROSPACE LTD		Work Order: 56750
Description: Saddle, Aft Inboard		Part Number: D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		0.440	.440	.440	0.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.003	8.006	8.003		
F	0.490	0.510		0.500	.500	.500	0.503		
G	0.257	0.262		0.259	0.259	0.259	.259		
H	0.375	0.380		0.377	0.377	0.377	.377		
I	0.490	0.510		0.499	0.500	.500	0.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.566	0.567	.567	0.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		0.124	0.124	0.123	.123		
Q	0.115	0.135		0.135	0.135	.135	0.135		
R	0.240	0.260		0.250	0.252	0.251	.250		
S	0.115	0.135		0.129	0.129	.128	.127		
T	0.178	0.198		0.188	0.188	0.188	.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.233	0.232	.233	0.233		
W	0.115	0.135		0.1325	.129	.130	0.132		
X	0.307	0.312		0.311	.310	.311	0.3105		
Y	0.760	0.765		0.760	.760	.761	0.762		
Z	0.352	0.372		0.365	.361	.360	0.360		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.624	.625	.625	0.627		
AC	0.053	0.073		0.063	.063	.063	.063		
AD	0.240	0.260		0.245	.250	.250	.250		
AE	1.500	1.520		1.514	1.5145	1.512	1.512		
AF	0.115	0.135		0.135	.135	.135	0.135		
AG	0.240	0.280		0.270	0.270	.270	0.270		
AH	0.240	0.260		0.243	0.244	.244	0.243		
AI	2.000	2.020		2.005	2.006	2.003	2.004		
AJ	0.023	0.043		0.033	.033	.033	.033		

Accept/Reject

Measured by: <i>DTJ / MW</i>	Audited by: <i>L.B.</i>
Date: <i>10/03/20</i>	Date: <i>10/03/22</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

2016-2017

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DART AEROSPACE LTD		Work Order: 56750
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Inspection Dwg: D2574 Rev. E		Page 1 of 1

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G	0.257	0.262		0.260	0.260	0.259	0.259		
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K	0.558	0.578		0.570	0.570	0.569	0.567		
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AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.270	0.270	0.270	0.270		
AH	0.240	0.260		0.243	0.244	0.245	0.245		
AI	2.000	2.020		2.004	2.004	2.005	2.005		
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